

Work Order ID 72200

Page 1

Wednesday, July 20, 2011 7:50:17 AM

Item ID: D4008-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Filler Splash Guard Assembly

Start Date: 7/19/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4008

B

100

0.00



Waterjet

FLOW CNC Waterjet

6061. 037

Memo

1-Cut as per Dwg (D4008-1)

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

0.00

R 11-8-11

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

R 11-8-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

0.00 *Sullosly*

QC

Memo

Quality Control



130

Bend as per dwg

0.00



0.00

Brake NC

Memo

Brake NC

Bend D4004-1 as per Dwg

*8/11/08-15*

140

QC5- Inspect part completeness to step on W/O

0.00



0.00

QC

Memo

Quality Control

Sullosly

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Item ID: D4008-041 Accept Setup Start
 Revision ID: Stop
 Item Name: Fuel Filler Splash Guard Assembly
 Start Date: 7/19/2011 Start Qty: 4.00 Cust Item ID:
 Required Date: 7/26/2011 Req'd Qty: 4.00 Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start
 QC: Date: SPC (Y/N): Date: Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

Hand Finishing

160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating									

Powder Coating

PS311A3
 Grey mat
 REMOVE PIN PRIOR TO POWDERCOATING
 Start Time: 1:05
 Oven Temperature: 320°F
 Finish Time: 1:30
 11/08/15

170	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

Quality Control

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Page 4

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Revision ID:					Stop	
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Start Date:	7/19/2011	Start Qty:	4.00	Cust Item ID:		
Required Date:	7/26/2011	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 		0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg								
190 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
200 	Identify as per dwg & Stock Location:	0.00							
Packaging	Memo	0.00							
Packaging									

Handwritten signature and date 11/18/15 with circled 6

Handwritten signature and date 11/18/15

Handwritten circled 6

Handwritten notes: 4/6 70245 (1x) EB 11/18/16 ST-108

Handwritten signature and date 11/18/16 with circled 62

W/O:		WORK ORDER CHANGES					
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Required Date: 7/26/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

211-08-18
(6)

Dart Aerospace Ltd

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Picklist Print

Wednesday, July 20, 2011 7:50:23 AM

Page 1

Work Order ID: 72200

Parent Item: D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly





Start Date: 7/19/2011

Required Date: 7/26/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.01.27 New issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032  6061-T6 Sheet 0.032"		Purchased	No			100	sf	101.5000	0.2735	1.151579			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		101.5							
					118106	96							
					16954	5.5							
D4008-5  Fuel Filler Splash Guard Hinge Half		Manufactured	No			180	Each	6.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST108		6							
					70913	6							
D4008-9  Spring		Manufactured	No			180	Each	14.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		14							
					70092	14							
D4008-7  Washer		Manufactured	No			180	Each	21.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST108		21							
					59662	1							
					70946	20							

IB11-8-11

3, 1, 6

16954

4
E 5/11/08/15

6

4
E 5/11/08/15

6

8
E 5/11/08/15

26 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Wednesday, July 20, 2011 7:50:24 AM

Page 2

Work Order ID: 72200

Parent Item: D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 7/19/2011

Required Date: 7/26/2011

Start Qty: 4.00

Required Qty: 4.00

MS20470AD3-3 Purchased

No

180 Each

9,584.000 5

20



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

9584

1065

1435

16941

8149

MS21042L08 Purchased

No

180 Each

315.0000 2

8



Nut

Location

Loc Qty

Loc Code

ST300

315

117739

115

118242

200

MS35206-S245 Purchased

No

180 Each

72.0000 2

8



Screw

Location

Loc Qty

Loc Code

ST294

72

113898

72

NAS1149DN832J Purchased

No

180 Each

1,596.000 6

24



WASHER

Location

Loc Qty

Loc Code

ST297

1596

117316

596

117887

1000

Handwritten signature
7/21/08/15

Handwritten signature
30
8
7/21/08/15

Handwritten signature
12
8
7/21/08/15

Handwritten signature
12
24
7/21/08/15

Handwritten signature
36

Wednesday, July 20, 2011 7:50:24 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Wednesday, July 20, 2011 7:50:24 AM

Page 3

Work Order ID: 72200



Parent Item: D4008-041



Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 7/19/2011

Required Date: 7/26/2011

Start Qty: 4.00

Required Qty: 4.00

D3941

Manufactured

No

180

f

43.7290

0.21

0.884211



Rubber Cushion



EP 7/14/08/15

1.26

Location

Loc Qty

Loc Code

ST408

43.72895

48512

43.72895

cut 1.25" long

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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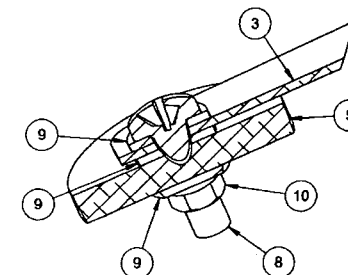
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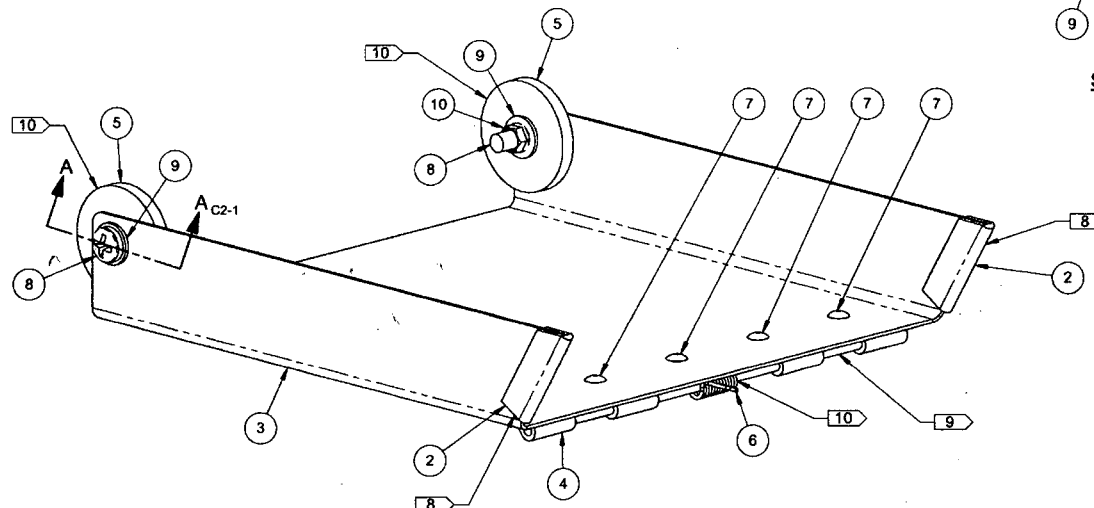
ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-041	AUX TANK FILLER SPLASH GUARD ASSEMBLY	JCA-M47-2-26
2	2	D3941-1	RUBBER CUSHION	
3	1	D4008-1	FUEL FILLER SPLASH GUARD CHANNEL	
4	1	D4008-5	HINGE HALF	
5	2	D4008-7	WASHER	
6	1	D4008-9	SPRING	
7	5	MS20470AD3-3	RIVET	
8	2	MS35206S245	SCREW	
9	6	NAS1149DN832J	WASHER	
10	2	MS21042L08	NUT	



SECTION A-A
SCALE: 2X B6-1
TYP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72200

PL 11-07-20



D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.15 lbs
- 8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER POWDER COAT
- 9) MASK HINGE PIN AREA BEFORE POWDER COAT
- 10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER POWDER COAT

B	ADD ALTERNATE RIVETS FOR -043, ZN D7-2	HS	10.11.03
A	NEW ISSUE	HS	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.03		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4008 TITLE SPLASH GUARD REV. B SHEET 1 OF 10 SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			

RELEASED
2011-05-30
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

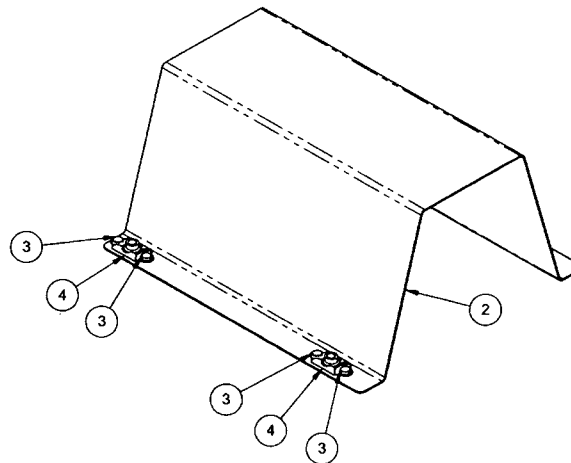
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-043	FUEL PUMP SPLASH GUARD ASSEMBLY	JCA-M47-2-29
2	1	D4008-3	FUEL PUMP SPLASH GUARD COVER	
3	8	MS20472M3-3	RIVET	B
4	4	MS21060L3	ANCHOR NUT	B



D4008-043 FUEL PUMP SPLASH GUARD ASSEMBLY

72200

RELEASED
2011-05-30
JW

NOTES:

- 1) MATERIAL:
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.46 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D4008 SHEET 2 OF 10
APPROVED		TITLE SCALE
DE APPR.		SPLASH GUARD NTS
DATE	10.11.03	COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

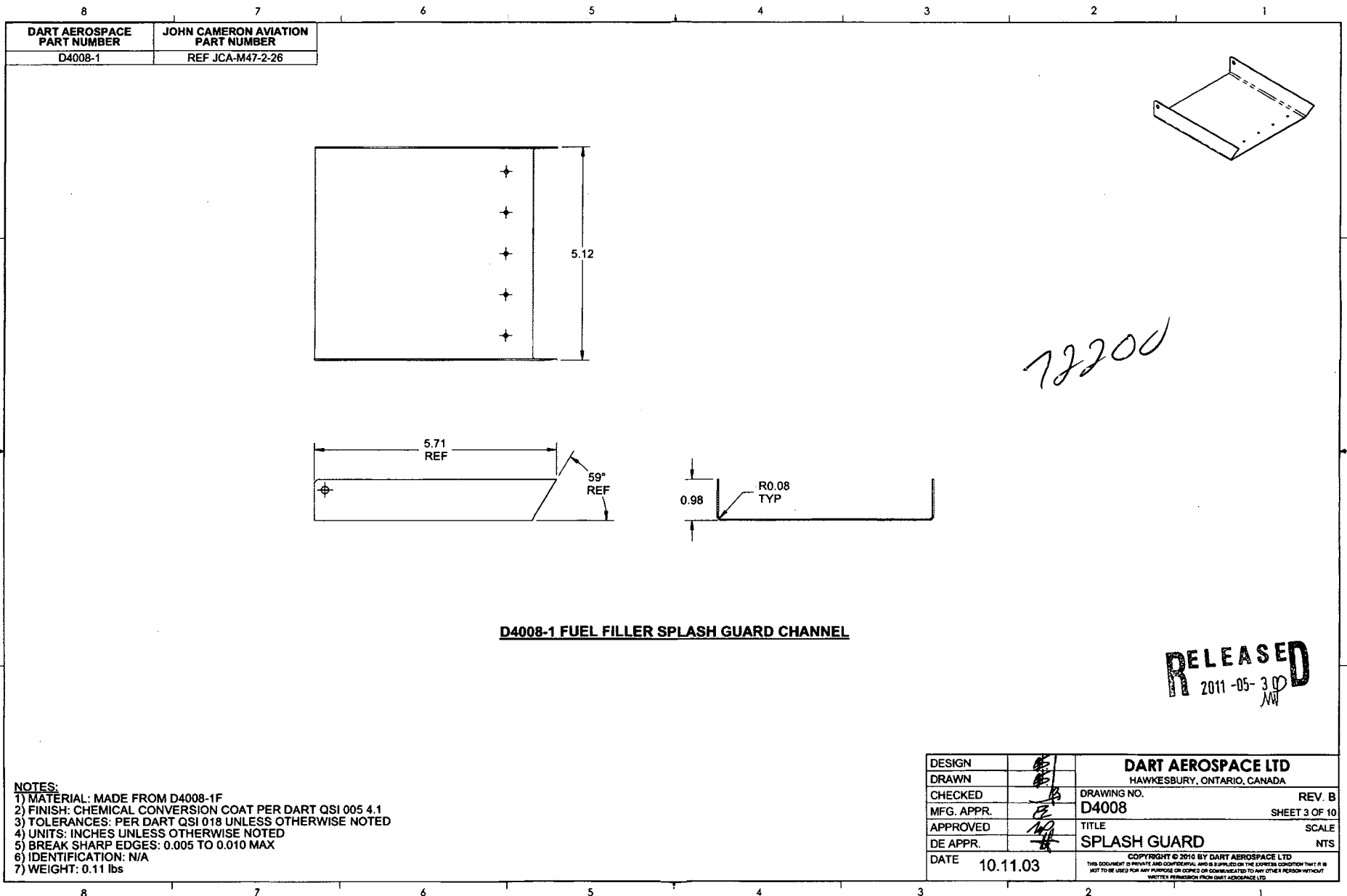
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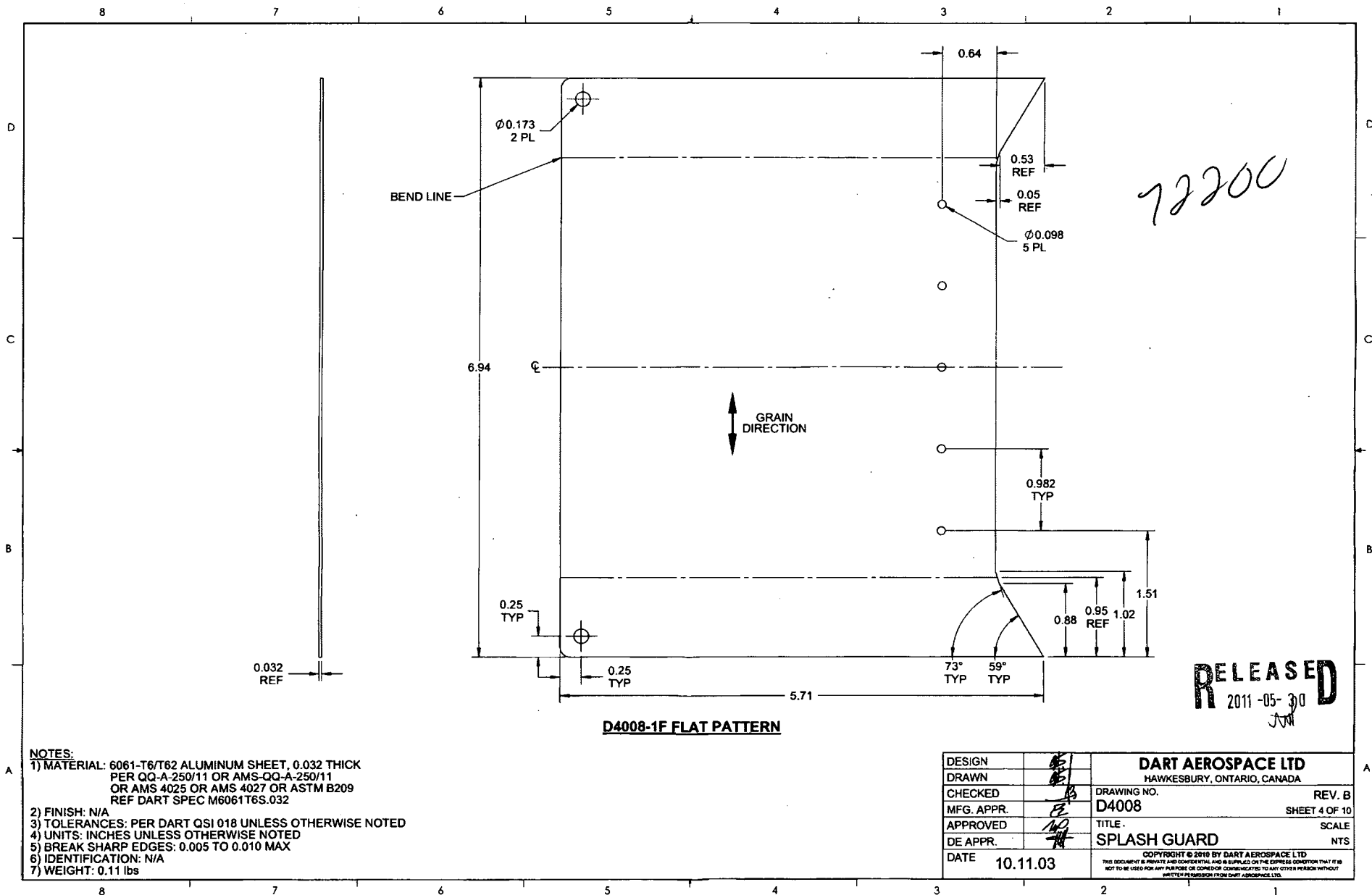
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